



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4975-1

Job Sheet 180697



Part No: D4975-1

Job Qty: 4 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 14.06.13 AS PER DWG REV.A DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	7/31/18	7/31/18	0.00	0.00	Start Up Waterjet		SC 18/07/18
100	Waterjet	4 pcs	7/31/18	7/31/18	0.00	0.40	Waterjet1		SC 18/07/18
120	QC	4 pcs	7/31/18	7/31/18	0.00	0.00	QC8		38
130	Brake NC	4 pcs	7/31/18	7/31/18	0.06	0.16	Brake NC 2		38 DAS
140	QC	4 pcs	7/31/18	7/31/18	0.00	0.00	QC6		38
150	HandFinish	4 pcs	7/31/18	7/31/18	0.00	0.14	HandFinish1		D.R 18/08/18
160	QC	4 pcs	7/31/18	7/31/18	0.00	0.00	QC7-4		AUG 1 3 2018
170	Packaging	4 pcs	7/31/18	7/31/18	0.00	0.00	Packaging3-2		AUG 1 5 2018
180	QC21-SA	4 Ea	7/31/18	7/31/18	0.00	0.00	QC21		AUG 1 6 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	.1000 sf (.025 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	0	287	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.250Inches ± 0.030	0.280 0.220	0,253	
2	Bracket	0.250Inches ± 0.030	0.280 0.220	0,251	
3	Bracket	0.680Inches ± 0.030	0.710 0.650	0,688	
4	Bracket	0.690Inches ± 0.030	0.720 0.660	0,697	
5	Bracket	0.617Inches ± 0.010	0.627 0.607	0,620	
6	Bracket	0.878Inches ± 0.010	0.888 0.868	0,880	
7	Bracket	1.380Inches ± 0.030	1.410	1,384	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION ☐ ☐ ☐ ☐ ☐ ☐		AGAINST DEPARTMENT/PROCESS Skid tube ☐ Cross tube ☐ Water Jet ☐		 Container No: S092905 Part: D4975-1 Job No: 180697 Serial No/Batch: S092905 Revision: Inspector: Exp Date: Instructions: Container No: S092905 Part: D4975-1 Job No: 180697 Serial No/Batch: S092905 Revision: Inspector: Exp Date: Instructions: Completed By Hand / Supervisor Approval Verification / QA Coordinator Approval					
Date : _____ Step #: _____		Description Work Order Deviat		 Container No: S092905 Part: D4975-1 Job No: 180697 Serial No/Batch: S092905 Revision: Inspector: Exp Date: Instructions: Container No: S092905 Part: D4975-1 Job No: 180697 Serial No/Batch: S092905 Revision: Inspector: Exp Date: Instructions: Completed By Hand / Supervisor Approval Verification / QA Coordinator Approval							
Root Cause <table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%;"> Power Loss/surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:50%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>		Power Loss/surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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OTHER : _____											

				1.350	
8	Bracket	2.590Inches ± 0.030		2.620	
				2.560	2,594
9	Bracket	0.098Inches + 0.004 - 0.001		0.102 0.097	0,098 Diameter
10	Bracket	0.768Inches + 0.010 - 0.001		0.778 0.767	0,768 Diameter

Plex 7/12/18 7:36 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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